

Work Order ID 60801

Friday, July 23, 2010 8:12:42 AM



Page 1

Item ID: D2958

Accept



Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 7/23/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-7-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2958

Rev E

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

F
E

10-7-26

10

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10-7-26

P10 ->

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

* 8/10/26

19

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2958 PAR #: Fault Category: Small fab - w. set NCR: Yes / No DCA: Date: 10/07/26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10/07/29

NCR: <u>60801</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/7/26	100	Found Qty +2 windows with Blow out from water jet Leads in / Leads out. R.C. process. Program		- Scrap + Destroy Qty x 2 no replace extra made.	was P2L jet on Thursday 10/7/26			
				- Fix Program to avoid blow outs from leads in/out				

NOTE: Date & initial all entries

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

0.00

Memo

0.00

Thermoform as per Dwg D2958 and Folio FTA005 Dwg.
Rev. E Folio Rev. B

(X8) BB 10/07/27

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Check product for scratches mal-formation or any other non conformances.

(X8) BB 10/07/27

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

X8 DC 10/07/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Water sand and buff to remove scratches as required ☐ Wrap in protective film

(X8)

(X/3) 12/07/28

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/28

(X8)

180



Packaging

Packaging

Identify as per dwg & Stock Location: 214

0.00

Memo

0.00

2/10/12/28 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Process Plan:

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Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/29 DJ
10-7-28
(8)

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 23, 2010 8:12:41 AM

Page 1

Work Order ID: 60801

Parent Item: D2958

Parent Item Name: Window



Start Date: 7/23/2010

Required Date: 7/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP E: 01.09.25 ☐ Done by outside contract ☐ SM
 IPP F: 07.06.26 Thermoform in house DL
 IPP G: 07.09.28 Rev E dwg EC verified by: DD
 IPP H: 08.11.24 Step 8 revised per w/o 41134 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			100	sf	54.0722	2.58	16.29474	30	10-7-06	

Location	Loc Qty	Loc Code
MAT	54.0722	
113204	4	
113861	10.4	
114673	39.6722	

114673

10

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

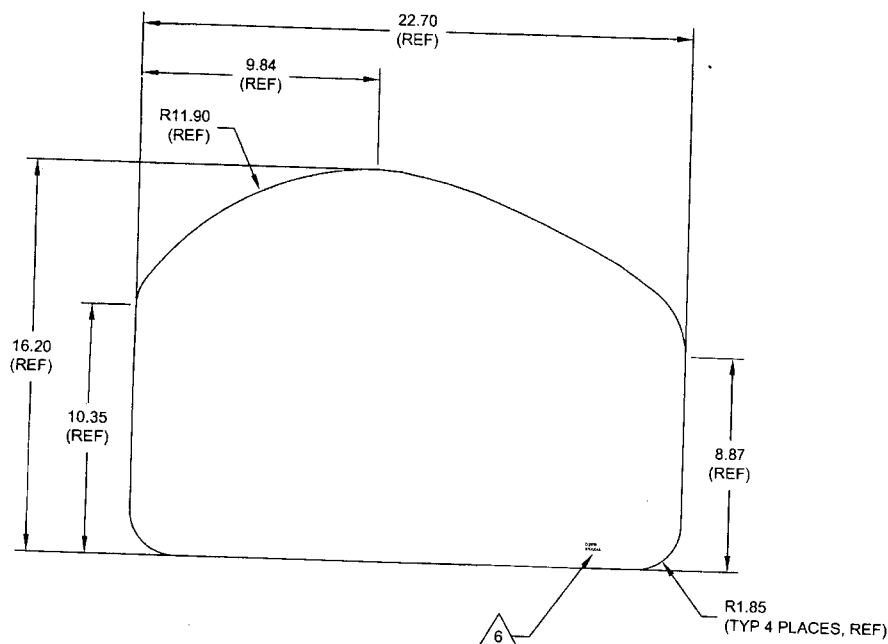
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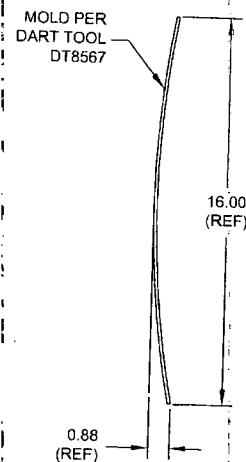
NOTE: Date & initial all entries



D2958 FLAT PATTERN

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567



#60801

RELEASED
07.09.22

REV.	DESCRIPTION	BY	DATE
E	UPDATE DIMS PER PAR 188	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO. D2958		
CHECKED	REV. E		
MFG. APPR.	SHEET 1 OF 1		
APPROVED	TITLE WINDOW		
DE APPR.	SCALE 1:5		
DATE	07.07.06		

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